Date

Thursday, 3/13/2008 10:18:59 AM

User

Kim Johnston

Process Sheet

Customer

Job Number

: CU-DAR001 Dart Helicopters Services

: 37920

Estimate Number

: 10175

P.O. Number This Issue

Prsht Rev.

First Issue

Previous Run

: 3/13/2008

S.O. No. :

: NC

: 11

: 37748

Type

: MACHINED PARTS

Part Number

Drawing Name

Drawing Number

: D2570 . D2570 REV B

: BUSHING

Project Number

: N/A

Drawing Revision

Material Due Date

: 4/10/2008

Qty:

Each

Written By

Checked & Approved By Comment

Re-format; Removed finishing; Material changeK

J

est F 07.07.06

rev B dwg EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0 M303R0750

303 Round Bar .75"

Comment: Qty.:

40.4775 f(s) 0.0810 f(s)/Unit Total:

Material: Ø0.750 AISI 303 SS Rod (M303R0.750)

M105801

Batch 1167077

M106633

<5G

08/03/17

398

398

2.0

HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

Machine as per folio FA198

Deburr



INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SECOND CHECK



398

4.0

3.0

QC2



Comment: SECOND CHECK

398

5.0

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Dart Aerospace Ltd

W/O:			WORK OR	DER CHANGE	S				
DATE	STEP	PR	OCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		*							
Part No	·	 PAR #:	Fault Category:		NCR: Yes	No DQ	A: <u>L</u>	Date:	08/03/1
					QA:	N/C Close	d:	Date: _	
NCR:			WORK ORDER NON	-CONFORMAI	NCE (NC	R)			
	T		Corrective	Action Section	. D				

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section E	Verification	Approval	Annroyal			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector		
						,				
				·						
		*								
	1 1		į l		1	1	1			

NOTE: Date & initial all entries

Date:

Thursday, 3/13/2008 10:18:59 AM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 37920

Part Number: D2570

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE





Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



398

Dart Ae	rospace	Ltd							1	
W/O:			V	VORK ORDER CH	ANGES					
DATE	STEP	PRO	CEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						¥	- 6 ° ° ° ° ° ° ° ° ° ° ° ° ° ° ° ° ° °			
Part No	:	PAR #:	Fault Ca	tegory:	NC	R: Yes	No DQ	A:	Date:	
				8-		QA: N	C Close	d:	_ Date: _	
NCR:		, V	ORK OR	DER NON-CONFO	RMANCE	(NCR)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Action Descrip	Section B	Sign & Date	Verific Secti	cation on C	Approval Chief Eng	Approval QC Inspector
								;		

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37920
Description: Bushing	Part Number:	D2570
Inspection Dwg: D2570 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

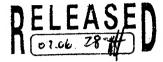
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.800	+/-0.010	1798	<u></u>			
0.060	+/-0.005	.058	-			
R0.010	+0.010/-0.000	.010				
Ø0.425	+0.000/-0.002	. 424	س ا			
Ø0.257	+0.005/-0.000	. 758				
Ø0.750	+/-0.010	-744				
0.030 x 20°	+/-0.010	.025				
					· · · · · · · · · · · · · · · · · · ·	
						· ·

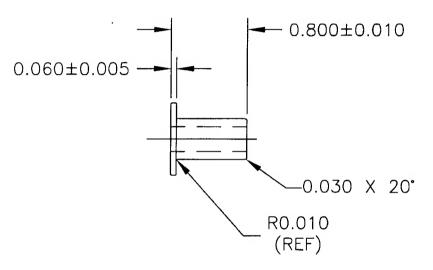
Measured by:	Audited by: In	Prototype Approval:	N/A
Date: 08-23.17	Date: 08/03/17	Date:	

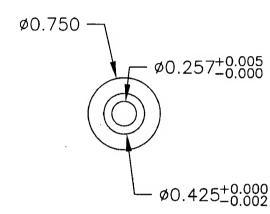
Rev	Date	Change	Revised by	Approved
Α	03.12.08	New Issue	KJ/RF	
В	04.02.23	Tolerance for Ø0.425 changed	KJ/RF	
С	07.07.17	Dimensions updated per Dwg Rev. B	KJ/JLM A	E



DESIG	n <i>PH</i>	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHEC	KED	APPROVED 1	DRAWING NO. REV. B
	#	H	D2570 SHEET 1 OF 1
DATE			TITLE SCALE
07.0	04.17		BUSHING 1:1
Α		96.09.16	NEW ISSUE
В		07.04.17	UPDATE NOTES







D2570 BUSHING

D2570 BUSHING

MATERIAL:

AISI 303 ROUND BAR (REF. DART SPEC. M303R)

2) FINISH: NONE

3) ALL DIMENSIONS ARE INCHES

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) BREAK ALL UNMARKED SHARP EDGES TO 0.010 MAX

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